

## Wet Sachet and Tip-on Specifications

### WET SACHET SPECIFICATIONS

Each 1mm of fill, the sachet's internal area must be at least 8 square cm.

The sachet must be free from excessive air, as much air as possible needs to be removed prior to sealing.

Under a compression test sachets must withstand at least 3,300 psi (1,500 kg) of pressure for 10 seconds.

As a fluage test, bonding must resist 5 hours under 2,200 psi (1,000 kg).

The laminate (what the sachet is made of) must be a minimum:

- 12 micron PET (Polyester)
- 12 micron Aluminium (Foil)
- 75 micron PE (Polyethylene)
- The Polyethylene must be modified linear low (LLPE) or equivalent.

Minimum overall size required for binding = 85mm x 55mm

Maximum overall size for binding = 160mm x 140mm

Maximum total weight for sachets, including fill = 20 grams

The liquid fill must remain at the same measurements throughout the production run

Sachets must be packed in nested cartons for ease of unpacking

Sachets must be packed so they do not curl or stick together, if this occurs they will not be able to be automatically fed

If more than 1 deck of sachets are packed in a carton, each deck must have a strong cardboard base so they will sit stable on the base

All sachets to be the same way up and the same way around

Sachet cartons to be strong and tailor made for a tight fit

## **APPROVAL OF TRIAL SAMPLES**

A minimum of 200 samples to be supplied as per the above specifications for pressure testing and a binding trial before full production of the sachet for the magazine

Due to the mechanics of tipping-on inserts, there may be occasions where a very small quantity of magazines is bound without the insert. As such it would be advisable NOT TO run wording offering a sachet within the magazine.

## **TIP-ON SPECIFICATIONS**

Minimum Size = 80mm deep x 100mm wide

Maximum Size = 200mm deep x 155mm wide

A single sheet tip-on must be a minimum weight of 150gsm

If the tip-on is other than a single leaf product the spine or closed edge of the product must be parallel with the spine when positioned on the page

A tip-on product is NOT guaranteed to be placed on the same position consecutively; there may be variations of up to 10mm depending on the weight and nature of the tip-on.

**It is a requirement that samples of all proposed tip-ons be submitted to Production Services for approval prior to ACP accepting them.**